

Work Order ID 73842

Friday, September 16, 2011 12:35:31 PM



Page 1

Item ID: D2661-2

Accept



Setup Start



Revision ID:

Item Name: Saddle, RH Fwd Aft Out 206

Stop



Start Date: 9/16/2011 Start Qty: 10.00

Required Date: 10/14/2011 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2661

Rev D

100

0.00



HAAS CNC VERTICAL MACHINING #1

RQ 11.10.17 5 2

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ Fixturing Inspection last completed
11.10.17 by RQ ☐ 1-Machine Step No 1 of Folio and visually inspect as
per attached Dimension Sheet ☐ 2-Machine Step No 2 of Folio and visually
inspect as per attached Dimension

110

0.00



CONVENTIONAL MILLING MACHINE

RQ 11.10.18 5 2

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00



QC2- Inspect parts off machine FAI/FAIB

RQ 11.10.18 5 2

QC

Memo

0.00

Quality Control

PTO

W/O: 73842

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2661-2 PAR #: NA Fault Category: Program *Prod/Eng* NCR: Yes No DQA: NA Date: 11-10-25
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: NA Date: 11/10/25






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.10.18	100	RC program malfunction block # N1197 Z value should be on next block tool 4 rapid into workpiece X2 R.C. Program error work	<i>AP</i> 11.10.19 PS1042	scrap & replace correct program Q102 B 73775	11.10.18 QA	<i>S</i> wled 70	<i>AP</i> 11.10.19 PS1042	<i>S</i> wled 70



NOTE: Date & initial all entries




Work Order ID 73842

Friday, September 16, 2011 12:35:31 PM

Page 2

Item ID:	D2661-2	Accept		Setup	Start	
Revision ID:						
Item Name:	Saddle, RH Fwd Aft Out 206				Stop	
Start Date:	9/16/2011	Start Qty:	10.00		Cust Item ID:	
Required Date:	10/14/2011	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		11/12/18		5	2		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				5	BR	11-10-19	
150  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00 0.00							

START TIME: 9:30
FINISH TIME: 10:00
OVEN TEMPERATURE:

M 117745

320

10:00

5x Ø M/L 11/10/19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73842

Friday, September 16, 2011 12:35:31 PM



Page 3

Item ID: D2661-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 9/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

5 BR 11-10-19

170

Identify as per dwg & Stock Location ST 470

0.00



Packaging

Memo

0.00

Packaging

5 Sp 11-10-19

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/19

MF 11-10-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 12:35:28 PM

Page 1

Work Order ID: 73842



Parent Item: D2661-2



Parent Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 9/16/2011

Required Date: 10/14/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C00.11.01 Removed P/O for Powder Coat - in house process EC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-003

Manufactured

No

100

Each

13.0000

1

10



Saddle Billet, 7075

29 11.10.18

Location

Loc Qty

Loc Code

MAT040

8

72226

8

MAT44

5

72226

5

B 73775

05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: 206 Saddle, Inboard, Left side		Part Number:	D2662-1
Inspection Dwg: D2662 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.121	.121	.122	.122	.122	
B	0.100	0.140		.122.105	.106	.118	.122	.122	
C	1.125	1.145		1.136	1.139	1.136	1.136	1.136	
D	0.615	0.685		.680	.680	.680	.680	.680	
E	0.240	0.260		.244	.242	.248	.248	.248	
F	1.313	1.343		1.316	1.319	1.320	1.320	1.320	
G	0.210	0.230		.215	.217	.220	.220	.220	
H	0.100	0.180		.125	.125	.125	.125	.125	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.576	1.578	1.575	1.575	1.575	
K	0.235	0.240		.238	.238	.238	.238	.238	
L	0.100	0.120		.110	.109	.109	.109	.109	
M	0.990	1.010		1.000	1.000	1.000	1.000	1.000	
N	0.510	0.515		.513	.513	.513	.513	.513	
O	5.990	6.010		5.998	5.997	5.997	5.997	5.997	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		.313	.313	.313	.313	.313	
S	0.315	0.322		.316	.316	.316	.316	.316	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		.796	.797	.794	.794	.794	
W	0.540	0.560		.548	.550	.550	.550	.550	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		.257	.257	.257	.257	.257	
Z	0.912	0.932		.918	.918	.921	.921	.921	
AA	0.490	0.510		.493	.495	.495	.495	.495	
AB	0.178	0.198		.188	.188	.188	.188	.188	
AC									
AD									
AE									
AF									
Accept/Reject									

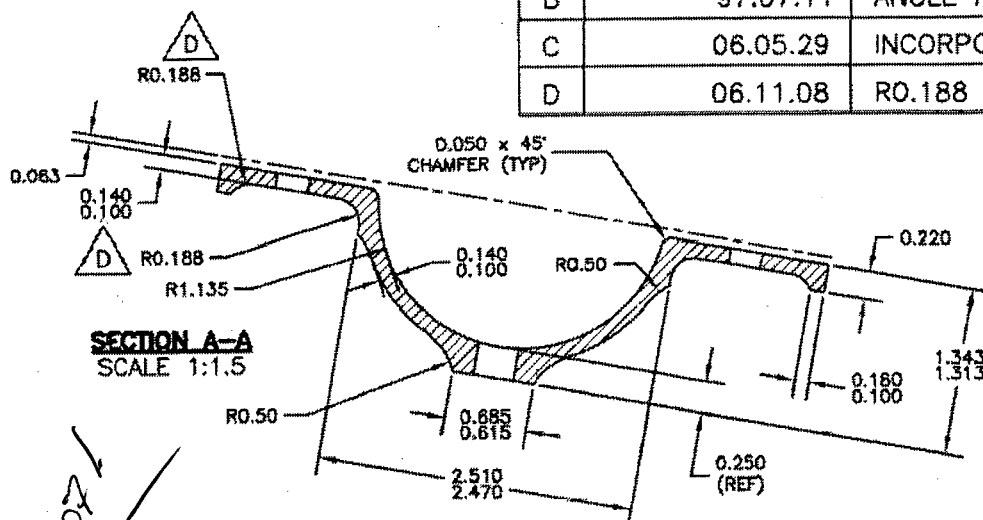
Measured by:	SL / 29 11.10.18
Date:	11-10-18

Audited by:	SL / 11.10.18
Date:	11.10.18

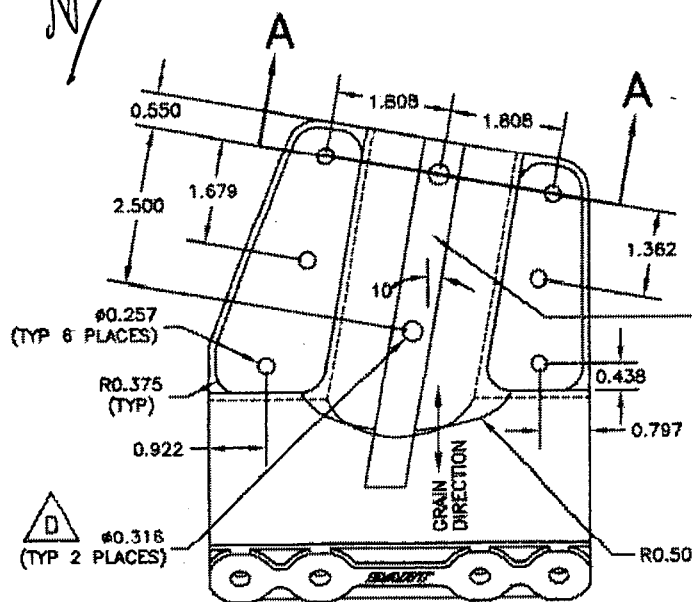
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



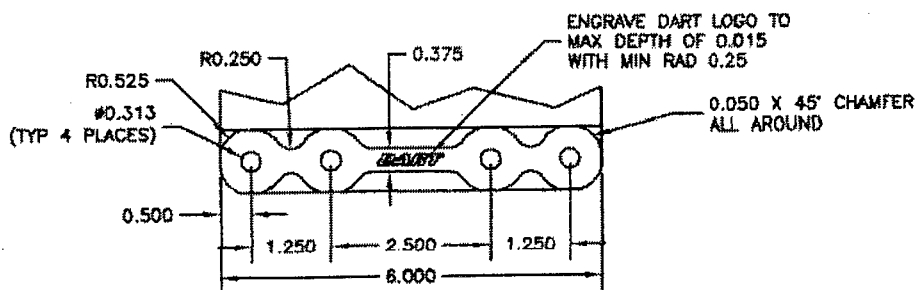
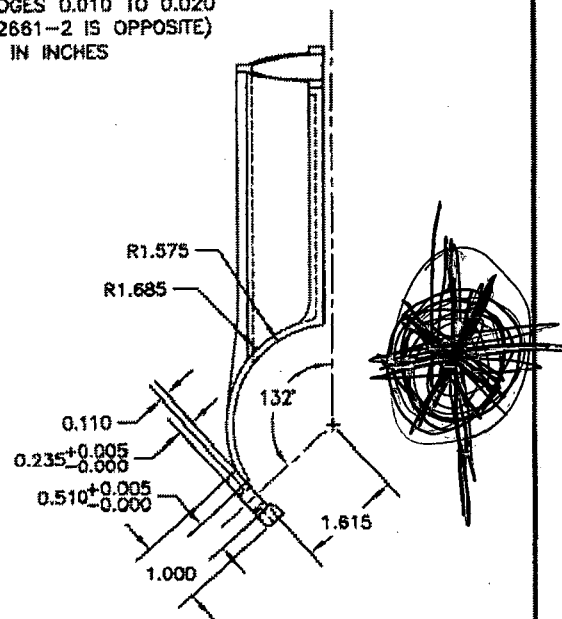
DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2661	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE OUTSIDE	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	



- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 5) D2661-1 SHOWN (D2661-2 IS OPPOSITE)
 - 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010



D2661-1 SADDLE OUTSIDE

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.